

Work Order ID 137525

137525

Page 1

Monday, October 05, 2015 11:14:53 AM

Item ID: D2855-3

Revision ID:

Item Name: Cap

Start Date: 10/5/2015 Start Qty: 25.00

Required Date: 10/5/2015 Req'd Qty: 25.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: ML5

Date:

OCT 05 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	Rev B								

100 0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 30008

Cast per Dwg D2855

Material Release Note Required

Supplier: Metallurgie SYCA

0.00

CY OCT 05 2015

50

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure Material Release Note is attached

0.00

0.01

Sp 50x 15-11-05

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

(50)

DAS
38
9-89

NOV 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				☐ OTHER : _____							

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Page 2

Item ID: D2855-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cap
Start Date: 10/5/2015 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 10/5/2015 Req'd Qty: 25.00 ***25*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
Small Fab	Memo	0.02							
	1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64"								
142 *142* Lathe Conv	Lathe Conv	0.00							
Conventional Lathe	Memo	0.00							
	1- Cut/TURN to length as per dwg 2- Deburr								
143 *143* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.01							

SOX 15/11/10 DAS 36 9-89

50 15-12-17 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
150	<i>M 133714.</i>					<i>50</i>	<i>0</i>	<i>15-12-23.</i>	<i>8 34 08</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>1:45</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>2:15..</i>								
160	QC3- Inspect Part Finish	0.00							
160						<i>50x</i>	<i>0</i>	<i>21 16/01/04</i>	<i>DAS 15 0:00</i>
QC	Memo	0.00							
Quality Control									
170	Small Fab	0.00							
170						<i>50x</i>	<i>0</i>	<i>21 16/01/04</i>	
Small Fab	Memo	0.01							
Small Fab	Install Inserts as per Dwg D2855								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180						50	0	16-01-4	DAS 34 9-89
QC	Memo	0.01							
Quality Control									
190	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
190						x50	0	11	10/6/16
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								
200	QC21- Final Inspection - Work Order Release	0.00							
200						MLJ		JAN 04 2016	
QC	Memo	0.04							
Quality Control									

MLJ JAN 04 2016

DQA: _____ Date: _____



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Picklist Print

Monday, October 05, 2015 11:14:57 AM

Page 1

Work Order ID: 137525

137525

Parent Item: D2855-3

D2855-3

Parent Item Name: Cap

Start Date: 10/5/2015

Required Date: 10/5/2015

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2855P		Purchased	No			110	Each	0.0000	1	25			
--------	--	-----------	----	--	--	-----	------	--------	---	----	--	--	--

D2855P

Cap

50x 8p 15-11-05

ALS7-1032-225	AELS8-1032-225	Purchased	No			170	Each	146.0000	2				
---------------	----------------	-----------	----	--	--	-----	------	----------	---	--	--	--	--

AI S7-1032-225 ✕

50 x 2 = 100

Insert

all 6/04/04

ALS4-1032-225

Location

Loc Qty

Loc Code

FG
118520
FP001
m131657

120
120
26
26

11133772

✓ 100

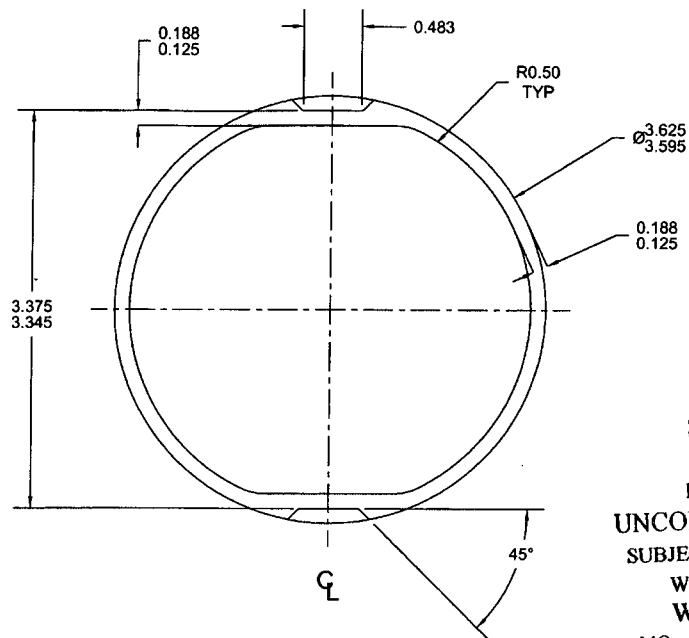
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

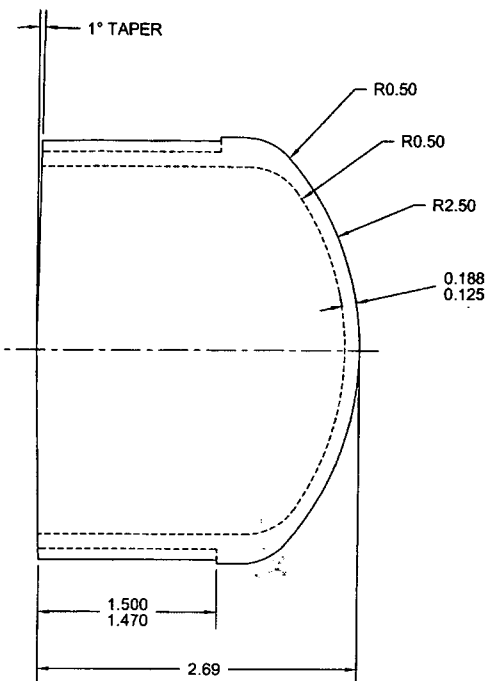
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☐ OTHER : _____																					



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137525 MJS
15-10-05



D2855C CASTING DETAIL



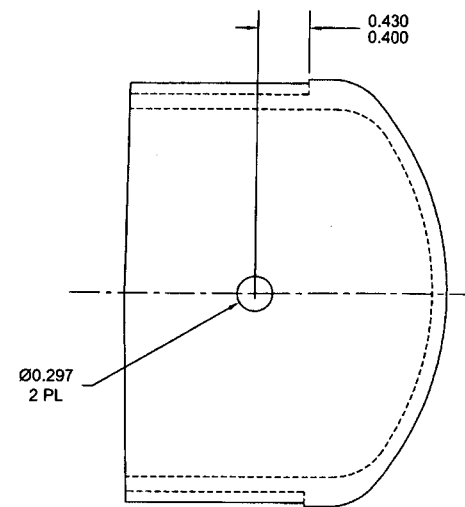
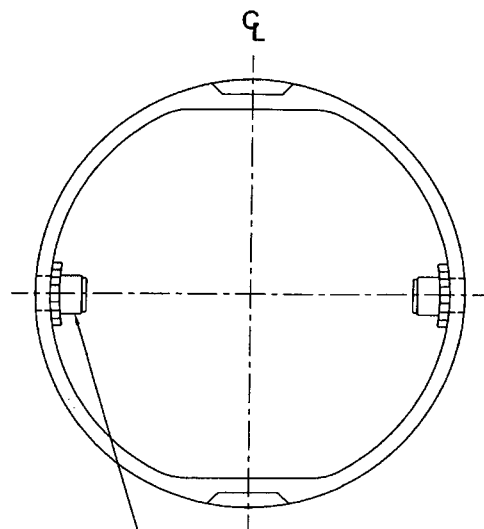
RELEASED
09/15/15 MJS

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2855	REV. B SHEET 1 OF 3
TITLE CAP	SCALE NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

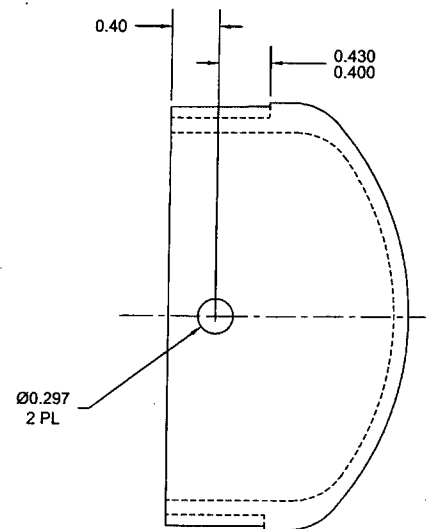
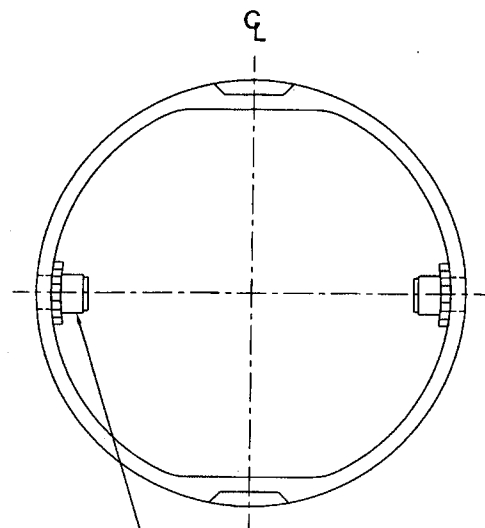
D2855 CAP
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

RELEASED
21/5/19

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EP	D2855	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	TH	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
24/1/1986

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D2855	SHEET 3 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30018**

Purchase Order Date 10/5/2015 3:14:53 PM

PO Print Date 10/6/2015

Page Number 1 of 2

Order From :

VC-MSY01

Ship To : DART AEROSPACE LTD

METALLURGIE SYCA
500 PRINCIPALE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

ST.DOMINIQUE, QUEBEC JOH 1LO

Contact Name

Vendor Phone 450-261-0853

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

FedEx Overnight collect

FOB

EXW - (Ex Works)

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P AS PER DWG D2855 REV. B B137525	Cap	10/23/2015 Yes 10/23/2015		50.00 Each	\$14.25	\$712.50
Line Total:							\$712.50
5	D2855P AS PER DWG D2855 REV. B B137568	Cap	10/23/2015 Yes 10/23/2015		50.00 Each	\$14.25	\$712.50
Line Total:							\$712.50

SP15-1105

PO Instructions: Fedex Acc#151793240

Note:

10/6/2015

METALLURGIE SYCATINC
500 RUE PRINCIPALE
ST-DOMINIQUE, QUÉBEC
J0H 1L0

N° D'ENR. DE TAXE
TAX REG. NO.

N° DE COMMANDE 30018

DATE 4-11-2015

ORDER NO.

VENDU À DART AEROSPACE LTD.

SOLD TO 1270, ABERDEEN STREET

EXPÉDIÉ À HAWKSBURY, ONT.

SHIP TO
ADDRESSE KGA-1K7

DATE D'EXPÉDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDEUR
SALESPERSON

104

D-2855

50X

1 BOX x 60 Pcs x 32 POUNDS ✓

1 BOX x 44 Pcs x 29 POUNDS ✓

2015-11-05

TRANSPORT FEDEX

THANKS FOR YOUR SUPPORT

TOTAL

546001

SIGNATURE

Blueline DCB27

FORMULAIRE DE VENTE - SALES ORDER ©Blueline®, 2010